

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2016-24 **Date Opened:** 12 Feb 2016 **Title:** Fabrication**Aircraft OEM:** Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket Body **Product Model:** Medium **Quantity:** 2**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
JR
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76411	3	Body Assembly	JR
76421	1	Regular Hoop	JR
76423	3	Mount Hoop	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking Tags (White) Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

JR
N/A
N/A

Traveller

Work performed by:

Print: Andrew Bartfai

ICC / Dual Inspection preformed by:

Print: Jason Rekve

Work Order closed by:

Print: Jason Rekve

Approved Manufacturing Facility 73-04

Sign: Sign: Sign: 

Form 20.D.03

SCA: AD07SCA: AD01SCA: AD01Date: 24-Feb-16Date: 24-Feb-16Date: 24-Feb-16

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Med. LH No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76411-01-02 Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-24

Remaining Tasks to be Performed: Mesh, powder

Signature: Dave Munt

Date: Feb 17/2016 Lic. No. / SCA AD-05

In Process



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AMF 73-04

Remarks

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Med. 4/H No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76411-01-02 Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-24

Remaining Tasks to be Performed: service mesh, cleanup,
inspect, powder coat.

Signature: [Signature]

Date: Feb 17/2016 Lic. No. / SCA AD-05

In Process



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AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

76423-01

Aircraft:

Eurocopter

Model: AS350

Description:

Mount Hoop

Supplier:

Aero Design

Color:

N/A

WO#:

2014-19

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76423-01	
Aircraft:	Eurocopter	Model: AS350
Description:	Mount Hoop	
Supplier:	Aero Design	
Color:	N/A	
WO#:	2014-19	PO# N/A

CARGO BASKET BODY FABRICATION - COMMON

2016-24

AS350 MED LH

w/ w/out

X2

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

→ 76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

→ Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2016-24

Date Open: 12 FEB 2016

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD-05

AD-05

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05

AD-05

3. Inspection

- a. Rim for complete welds

AD-05

AD-05

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 - 1. Attachment lugs are on inboard side.
 - 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

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AD-05

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

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6. Inspection

- a. Frame assembly for complete welds.

AD-05 AD-05

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

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- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require $\frac{1}{2}$ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete

(initial or SCA #)

AD-05 AD-05

8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

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10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

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11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

OK OK

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

ak ak

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

CARGO BASKET HOOP FABRICATION - 76422

General

These instructions apply to cargo basket forward attachment hoop 76422-01. Refer to the following drawings, at the current revision, for dimensions and details:

76421, Revision 0 – Hoop

76422, Revision 0 – Attachment Hoop

Work Order: 2016-24

Complete
(initial or SCA #)

Date Open: 12 FEB 2016

1. Machining

- Start with 76421-01 hoop as stock.
- Setup manual milling machine with standard steel vise jaw, with a backup bar to prevent the hoop from deflecting while cutting. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0.
- Using 5/8" (0.625) end mill, mill into side of tube in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

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2. Welding

- Attach two 69823-02 lugs to 11" spacing jig using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. above. Centre bolts on hoop.
- TIG weld lugs into hoop. Weld all around both lugs.
- Record lug and welding rod PO/WO on attached material list.
- Tag in process hoop(s) and place into stock.

AD-05 AD-05

3. Finishing and Inspection

- Run 3/8-24 tap through welded lugs.
- Inspect hoop for conformity to drawing.
- Tag complete and inspected hoop(s) and place into stock.

JK. JK.

Work Order: 2016-24Material Tracking Sheet
Eurocopter AS350 / AS355
Hoop Fabrication

1 of 2

Date Opened: 12 FEB 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1			76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	N/A
Step 1			76421-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	
Step 2				Welding		
	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	
	. A/R		--	Welding Rod	ER70S-2	N/A
Step 3				Inspection	None	
	2		76422-01 <i>gc.</i>	Hoop - attachment (forward)		
Step 1			76421-01 <i>gc.</i>	Fabrication		
	. 1		76421-01	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14089
Step 2				Welding		
	. 2		69823-02	Lug	1018 Steel, 5/8" Rod	2015-67
	. A/R		--	Welding Rod	ER70S-2	14005
Step 3				Finishing and Inspection	None	

Work Order: 2016-24Date Opened: 12 Feb 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Body Fabrication

1 of 2

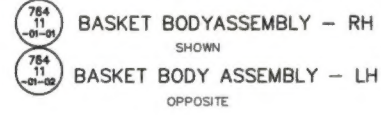
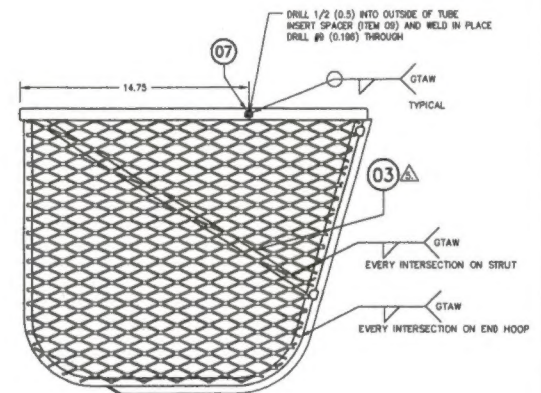
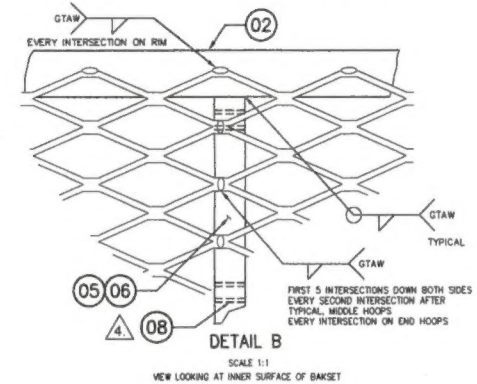
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>2</u>		76411-01- <u>02</u>	Basket Assembly	(-01 RH, -02 LH)	
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15072/14099</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 2		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>2014-29</u>
	. 1	84262	76421-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>12123/11048</u>
	. 1		76422-01	Attachment Hoop (forward)		<u>See hoop tracking sheet</u>
	. 1		76423-01	Attachment hoop (aft)		<u>2014-19</u>
	. 4		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14099</u>
	. 1		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14099</u>
Step 4.g.		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14099</u>
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14099</u>
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 75")	3/4-16F Expanded Mild Steel sheet	<u>15037</u>
	. 2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	<u>15037</u>



Work Order: 2016-24Date Opened: 12 Feb 2016Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Weld Mesh</i>		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	PO# 15059
Step 9				<i>Weld Basket Components</i>		
	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	WO# 2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028
Step 9.b.	. 1		--	Cap	1018 Mild Steel, 0.032" Sheet	PO# 2019
	A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 10				<i>Clean Up</i>	None	
Step 11				<i>Inspection - Final Assembly</i>	None	
Step 12				Powder Coating		

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	25 JAN 00
1	ADDED LH ASSEMBLY	RR	05 MAR 00
2	CHANGED HANDLE BRACKETS	SJC	27 JAN 10
3	TITLE BLOCK UPDATED; WELDING ROD UPDATED; REFERENCE DIMS ADDED CENTRE HOOP MOVED; SPACER (7) MOVED; CAP (10) ADDED	SJC	11/07/2014

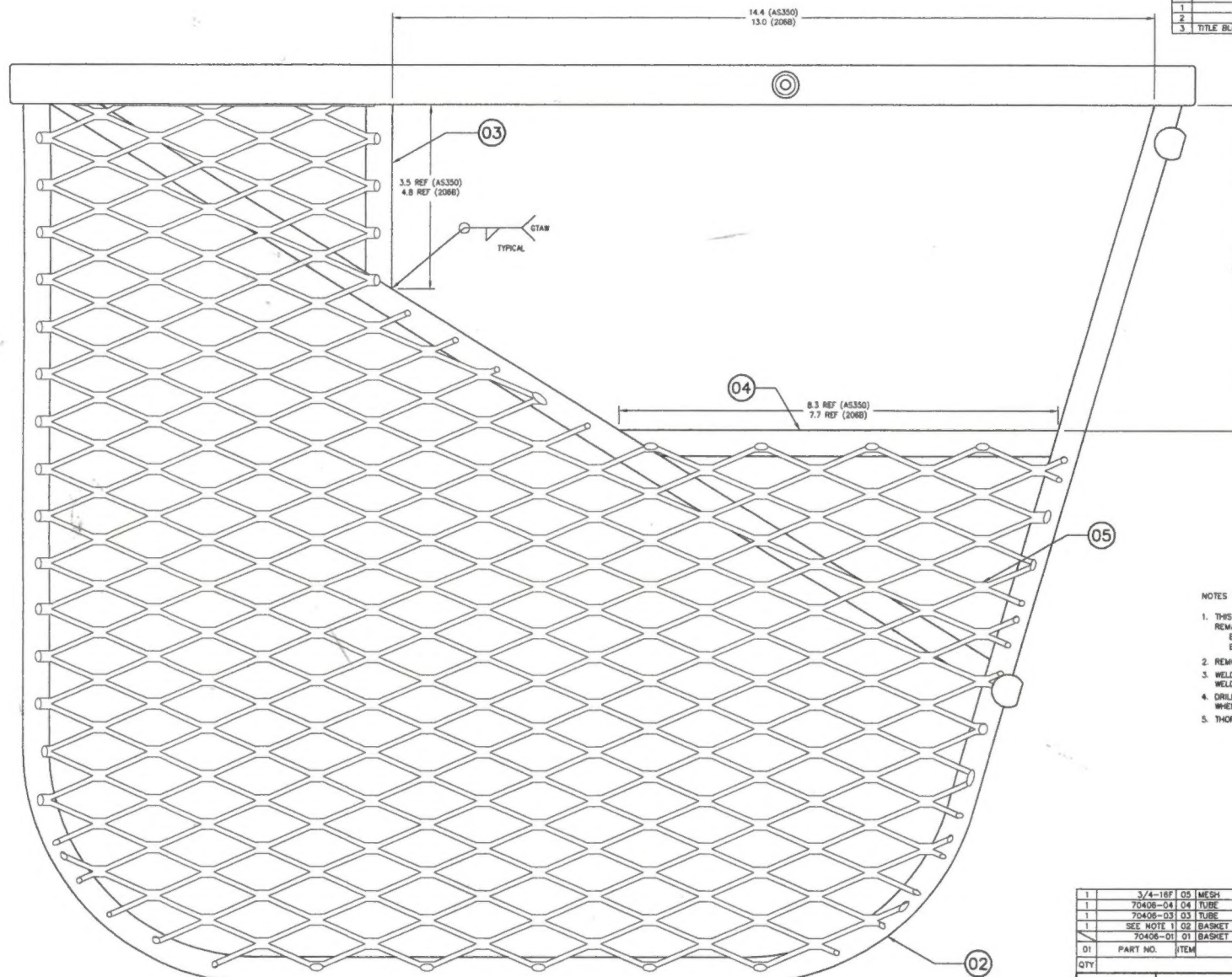


- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. PRIOR TO WELDING, DRILL #30 (0.120) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2855C.
4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO E70TS-2 OR EQUIVALENT.
STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
-  INSTALL TIE IN (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 BEFORE WELDING HOOPS TO RIM.
-  STRUT MEMBER ON FWD END OF BASKET ONLY.
6. FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

1	1	--	10	CAP					ASIS 1010/1020	0.5 X 0.035 SQR TUBE
A/R	A/R	3/4 - 18F	09	MESH					COMMERCIAL	
1	1	84262-01	08	BASKET HANDLE PROVISIONS	ASSEMBLY					
1	1	49215-01	07	SPACER						
1	1	76421-01	06	HOOP						
1	1	76423-01	05	ATTACHMENT HOOP						
1	1	76422-01	04	ATTACHMENT HOOP						
A/R	A/R		03	SQUARE TUBE			4730 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR TUBE	
A/R	A/R		02	SQUARE TUBE			4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR TUBE	
1	1	76411-01-02	-01-02	BASKET BODY ASSEMBLY - LH						
1	1	76411-01-01	-01-01	BASKET BODY ASSEMBLY - RH						
-01-02	-01-01			DESCRIPTION		MATERIAL/NOTE		MATERIAL SPEC		STOCK SIZE
QTY		LIST OF MATERIALS								
APPROVALS DRW: R. RATHWELL CHECKED: E. BURGMAN					 AERO DESIGN LTD. 9088A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604-686-8276 www.aerodesign.com					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES .XXXX ±0.010 ±1/2" .XXX ±0.03 .X.X ±0.1					EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY (MEDIMUM)					
SCALE 1 : 4 SHEET 1 OF 1					DIMG SIZE A1		DIMG NO. 76411		REV. 3	

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL 206B	BJC	DEC 22/08
2	MODIFY OPENING	BJC	OCT 27/11
3	TITLE BLOCK UPDATED; LONG/EXTRA LARGE CONFIGURATION ADDED TO SHT. 2	BJC	14/07/2014



NOTES

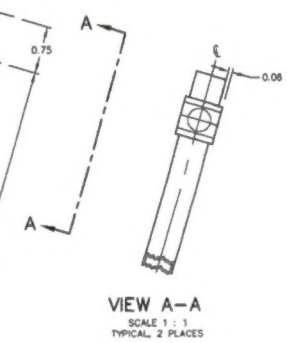
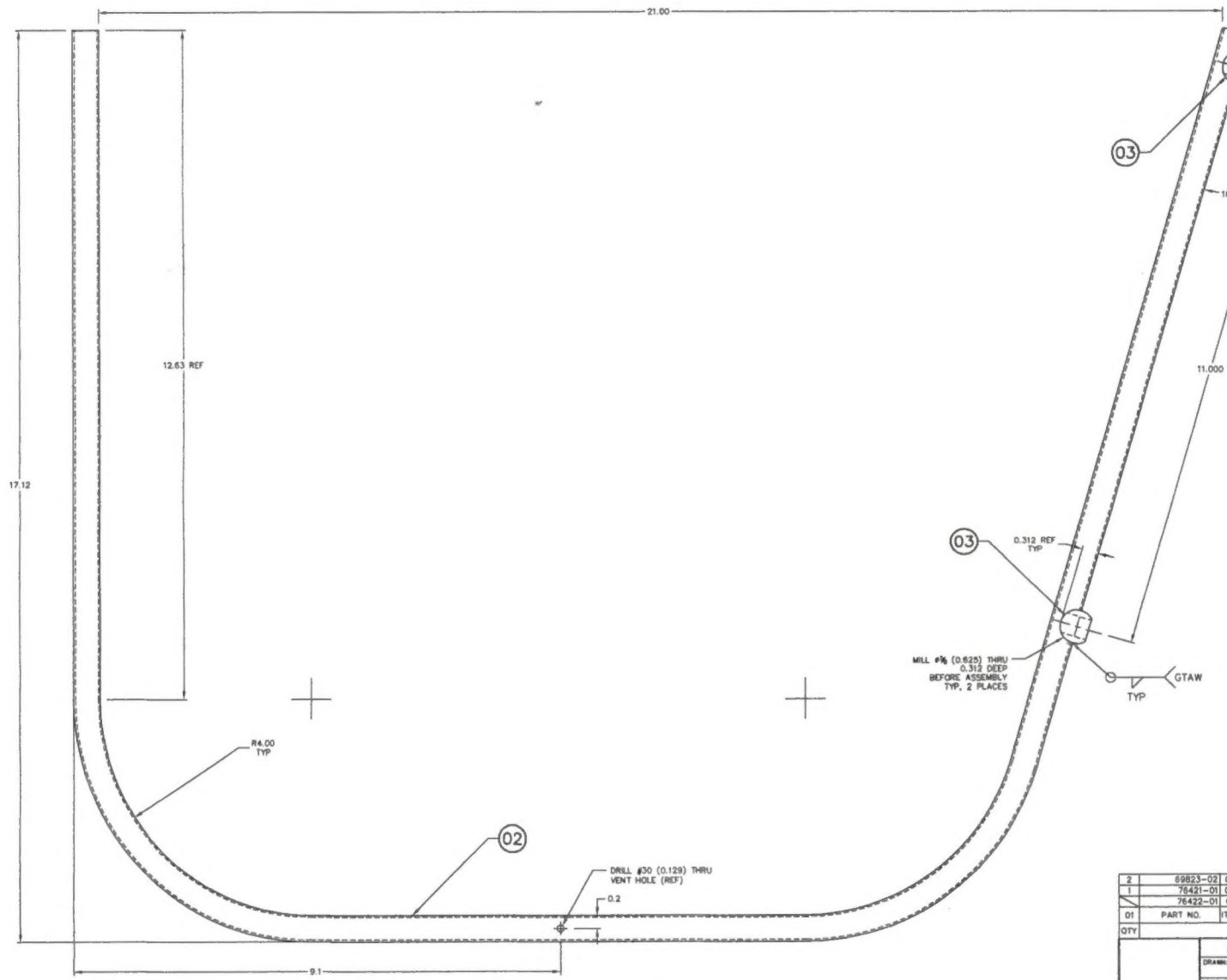
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION FOR THE FORWARD END ONLY. REMAINDER OF BASKET IS TO BE IN ACCORDANCE WITH THE FOLLOWING DRAWING: EUROCOPTER AS350/AS355: 76411 (MEDIUM) OR 77811 (SHORT) BELL 206B: 80211 OR 80311
2. REMOVE ALL BURRS AND BREAK SHARP EDGES
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. DRILL #30 (0.125) HOLES TO VENT TUBES INTO BASKET HOOP AND/OR RIM. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

(01) BASKET BODY ASSEMBLY
EUROCOPTER AS350 SHORT/MEDIUM SHOWN
BELL 206B SIMILAR

1	3/4-18F 05 MESH	MILD STEEL	COMMERCIAL	
1	70406-04 04 TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE
1	70406-03 03 TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1 02 BASKET BODY ASSEMBLY			
1	70406-01 01 BASKET BODY ASSEMBLY - MODIFIED FORWARD END			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL MATERIAL SPEC STOCK SIZE
QTY				
LIST OF MATERIALS				
APPROVALS		DATE	 AERO DESIGN LTD. 9808A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.463.5719 www.aerodesign.ca	
DRAWN: JEFF CLARKE		19 MAR 2008		
CHECKED: E. BURGOIN				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			QUICK RELEASE CARGO BASKET OPEN FORWARD END MODIFICATION	
DECIMALS		ANGLES		
X.XXX ±0.010		±1/2°		
X.XX ±0.03				
X.X ±0.1				
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 2		A1	70406	3


2016-24 JK.
2016-28

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; VENT HOLE ADDED; NOTE 2 REMOVED; 3 MOVED TO 2	BJC	11/07/2014



- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2683C. WELDING ROD SHALL CONFORM TO AMS ER70S-2 OR EQUIVALENT.

(01) ATTACHMENT HOOP ASSEMBLY
SCALE 1 : 1

2	69823-02	03	LUG			
1	76421-01	02	HOOP			
	76422-01	01	ATTACHMENT HOOP ASSEMBLY			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
APPROVALS			DATE			
DRAWN: R. RATHWELL			24 JAN 08			
CHECKED: E. BURGOW						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1			 AERO DESIGN LTD. 6080A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8B 0G3 TEL: 250-463-2078 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET ATTACHMENT HOOP ASSEMBLY						
SCALE 1 : 1			QWG SIZE		QWG NO.	REV.
SHEET 1 OF 1			A1		76422	1